

Date: Tuesday, 7/1/2008 10:47:17 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 40161	
Estimate Number : 10770	
P.O. Number :	Part Number : D3462041
This Issue : 7/1/2008 S.O. No. :	Drawing Number : D3462 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : <i>PL</i> <i>9/08.07.09</i>
Previous Run : 35859	Material :
Written By :	Due Date : 7/30/2008 Qty: 4 Um: Each
Checked & Approved By : <i>08.07.01</i>	
Comment : EST REV. A 05.11.18 NEW ISSUE EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34623	Lug
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Flange

Pick:

Qty	Part Number	Description	Batch
1	D3462-3	flange	<i>B37790</i>

PL 8-10-28

2.0	D34621	BRACKET ASSEMBLY
-----	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Base Flat Pattern

Pick:

Qty	Part Number	Description	Batch
1	D3462-1F	base flat pattern	<i>B33828</i>

PL 8-10-28

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3462

M106115

PL 8-10-28

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

11/08/10/23

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S08/06/23 44 041

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 10:47:17 AM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 40161

Part Number: D3462041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M109152



(4x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15
400 °F
3:45

m-1 08/10/24

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AS 08/10/27 KY

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST96

AS 08/10/27 W

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/27 J

Job Completion



W 08.10.27

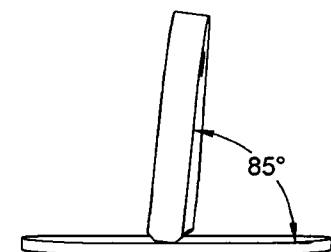
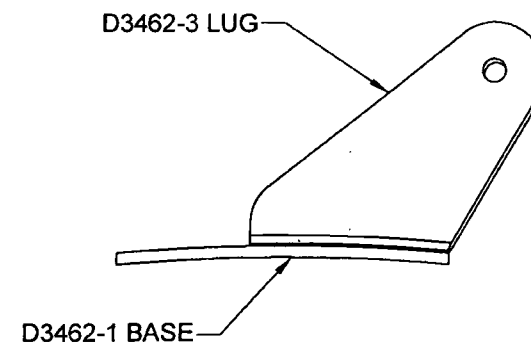
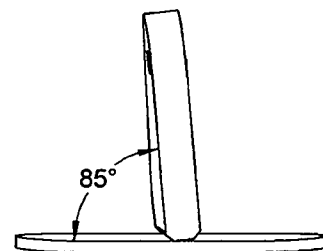
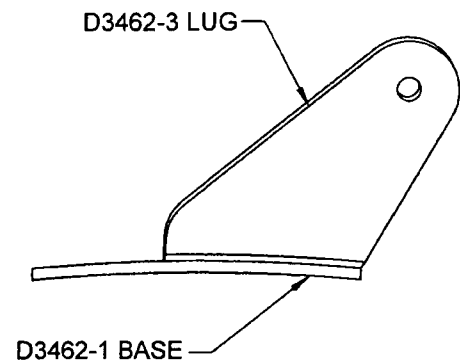
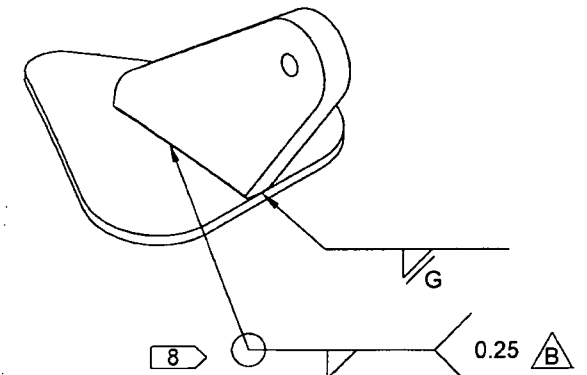
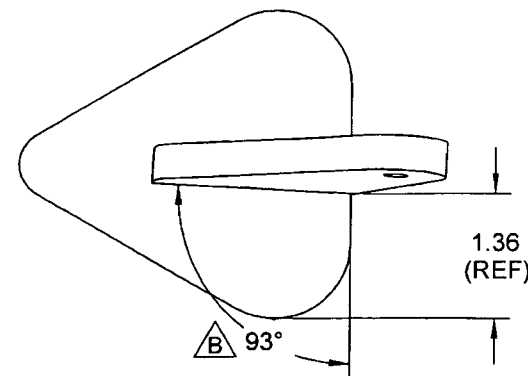
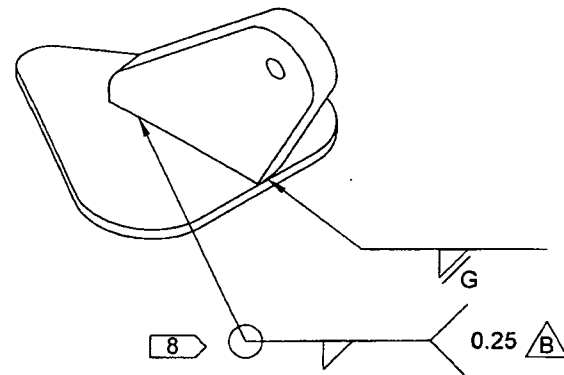
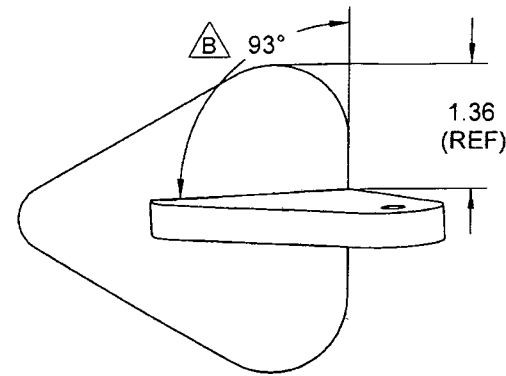
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.75 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

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WORK ORDER
NO. 40161

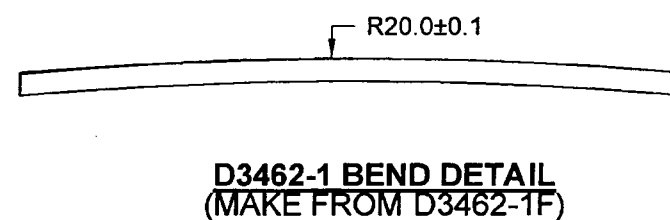
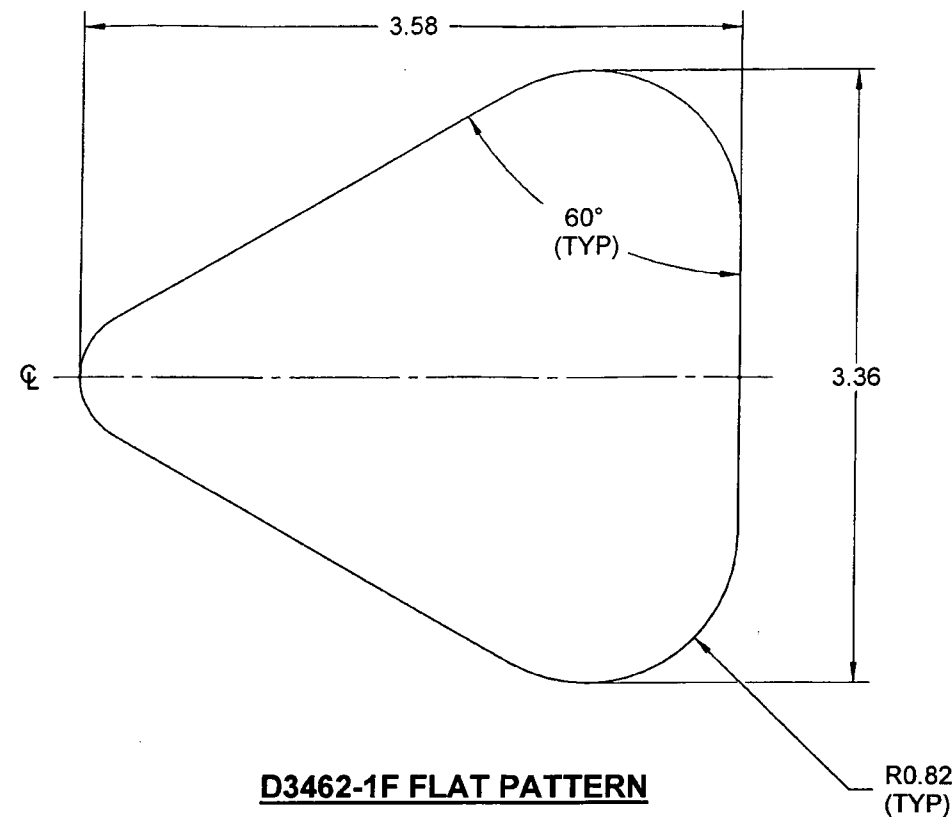
RELEASED
080707 1/2

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.24		

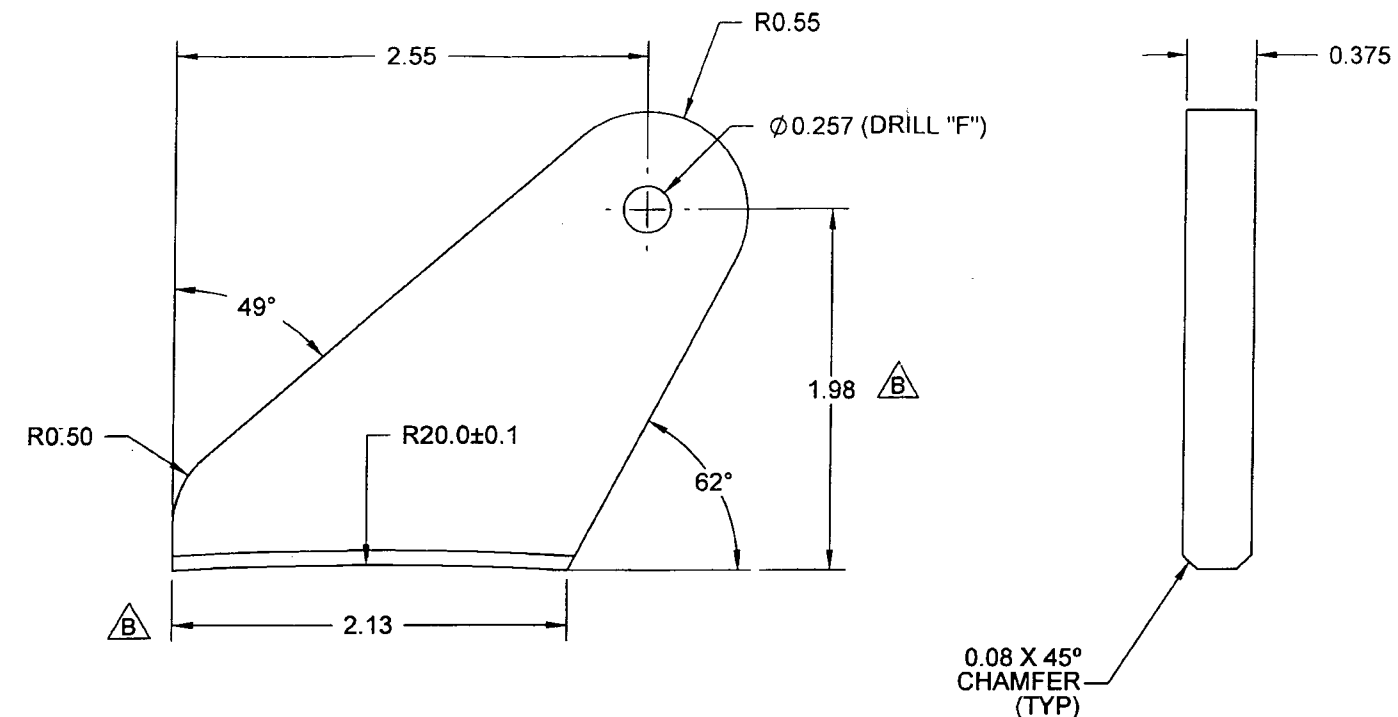
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3462** REV. C
SHEET 1 OF 2
TITLE **BRACKET ASSEMBLY** SCALE 1:2

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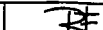
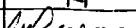




- NOTES:
- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED), 2B FINISH
(REF. DART SPEC. M304S11GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs



- NOTES:
- 1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

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8.07.07

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3462	SHEET 2 OF 2
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DE APPR.		BRACKET ASSEMBLY	1:1
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